



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4324-045

Job Sheet 172283



Part No: D4324-045

Job Qty: 4 ea

Part Name: Cushion Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/14/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEET 4 IPP Rev:A 14.04.25 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	4 pcs	3/9/18	3/9/18	0.00	0.00	Purchasing		AP 18/23/06
110	Packaging	4 pcs	3/9/18	3/9/18	0.00	0.00	Packaging2		AP 18/23/06
120	QC	4 pcs	3/9/18	3/9/18	0.00	0.00	QC6		38
130	Packaging	4 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-2	5/456	9-89
140	QC21-SA	4 Ea	3/9/18	3/9/18	0.00	0.00	QC21		MAR 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4324-045P	Cushion Assembly	4 pcs (1 ea)	100-Purchasing	
	P0039102	203	FEB 23 2018	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D4324-045P	4	0	0

Part Specifications

Specifications could not be found.

Plex 2/14/18 2:09 PM Dart.Gagnon.Michelle

CONTAINER NO. 001000

Cushion Assembly

PART NO: D4324-045

Serial No/Batch: S048609

Revision:

Operation:

Change No:

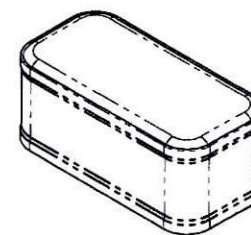
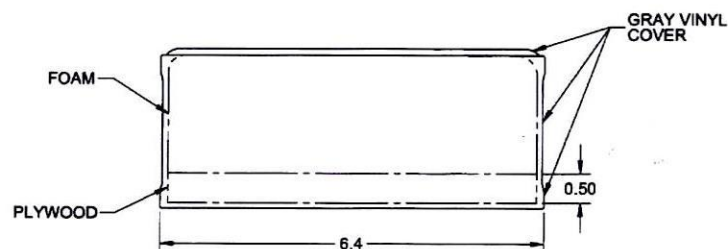
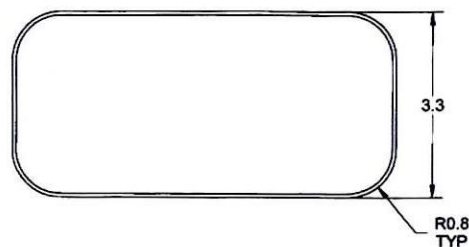
Packaging

Mfg Date: 03/06/18

Job No: 172283

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 WITHOUT NOTICE
 WORK ORDER
 NO. 172283 *uml*

FEB 14 2018



D4324-045 CUSHION ASSEMBLY
 (REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

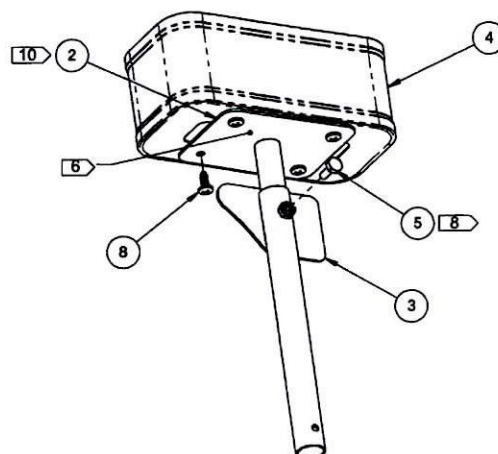
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 2014-04-23
WD

- NOTES:
- 1) MATERIAL: AS SHOWN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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ITEM	QTY -011	P/N	DESCRIPTION
1	X	D4324-011	ARM REST ASSEMBLY
2	1	D4324-041	ARM REST WELDMENT
3	1	D4324-043	ARM SUPPORT ASSEMBLY
4	1	D4324-045	CUSHION ASSEMBLY
5	3	AN3-4A	BOLT
6	1	AN3-12A	BOLT
7	3	MS21075L3	NUT PLATE
8	4	MS51881-45C	SCREW
9	3	NAS1149F0332P	WASHER
10	1	NAS1149F0363P	WASHER



D4324-011 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-16) 

NOTES:

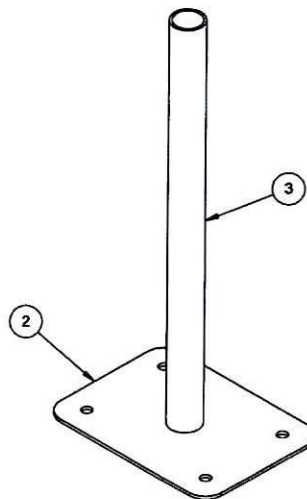
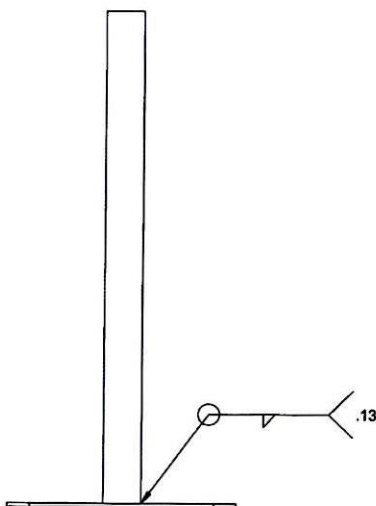
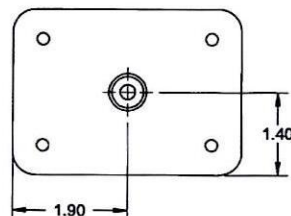
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.83 lbs
- 8) INSTALL HARDWARE HAND TIGHT ONLY
- 9) BAG LOOSE HARDWARE
- 10) CENTER D4324-041 ON D4324-045 AS SHOWN

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B	ADD D4324-011 (ZN B4-1) & D4324-045 (ZN B4-4); REVISE D4324-041 NAME (ZN B4-2, D4-2); ADD Ø0.204 HOLES (ZN D5-5) & Ø0.25 HOLE (ZN D4-5); 8.30 WAS 6.95 (ZN C5-7); REVISE IDENTIFICATION NOTES; REF PAR13-319	RF	14.04.03
A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4324-041	ARM REST WELDMENT
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST WELDMENT
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) B

NOTES:

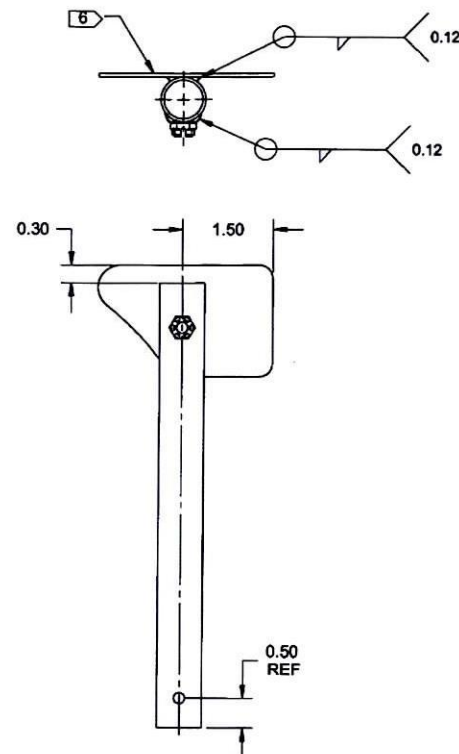
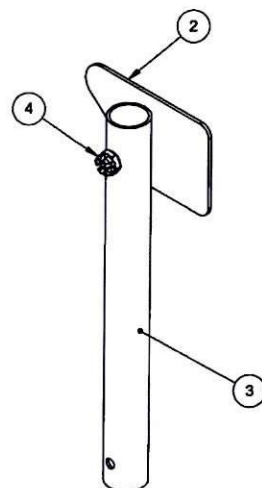
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) WELD PER DART QSI 004

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2048902, PART OF P/N EA20469-16) /B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	DC
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	14.04.03

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4324	REV. B SHEET 3 OF 7
TITLE ARM REST ASSEMBLY	SCALE NTS
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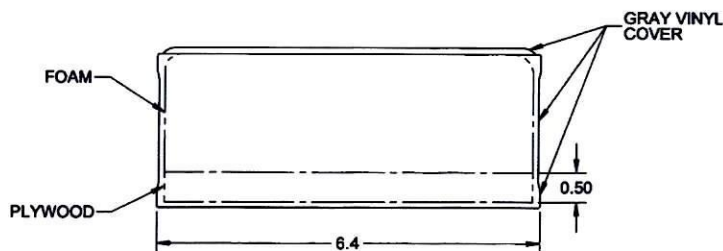
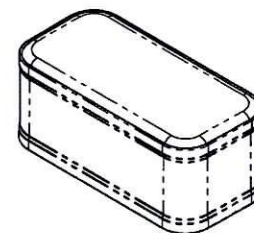
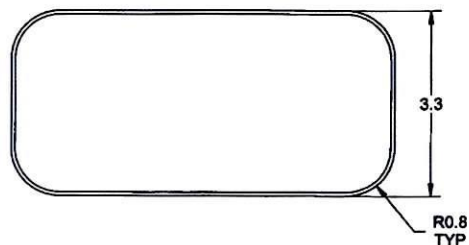
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D4324-045 CUSHION ASSEMBLY
(REF. EAGLE DRAWING No. D2048902, PART OF P/N EA20469-16) 

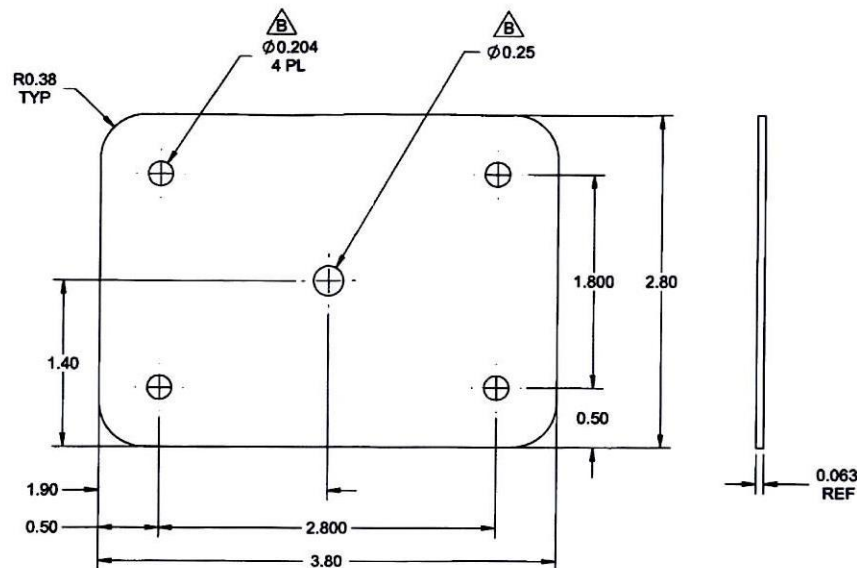
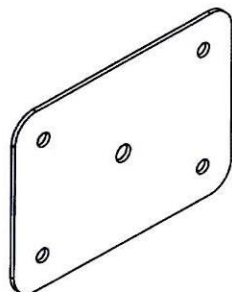
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WD

- NOTES:**
- 1) MATERIAL: AS SHOWN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle B$

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

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	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. B
	MFG. APPR.	DD	D4324	SHEET 5 OF 7
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	ARM REST ASSEMBLY	NTS
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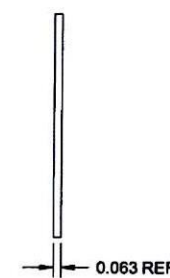
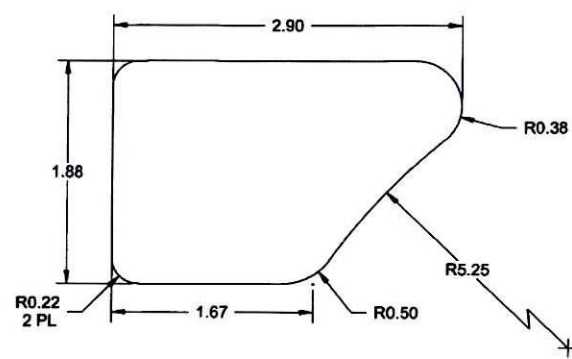
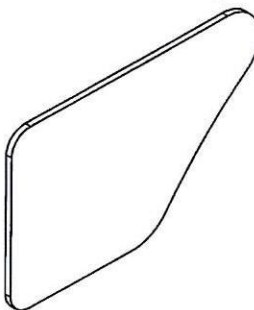
8 7 6 5 4 3 2 1

D

C

B

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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RELEASED
2014-04-23

8 7 6 5 4 3 2 1

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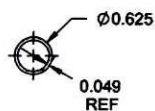
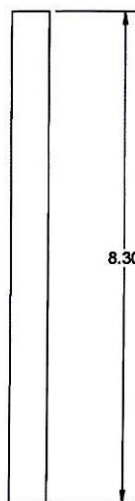
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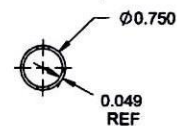
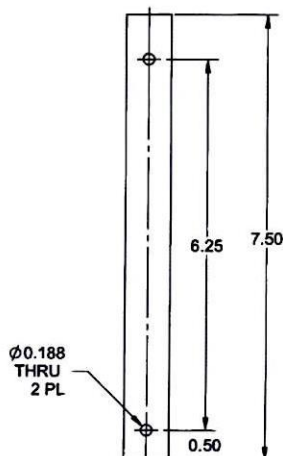


D4324-5 TUBE



D4324-5 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)



D4324-7 TUBE

D

C

B

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4324-5 = 0.21 lbs
D4324-7 = 0.23 lbs

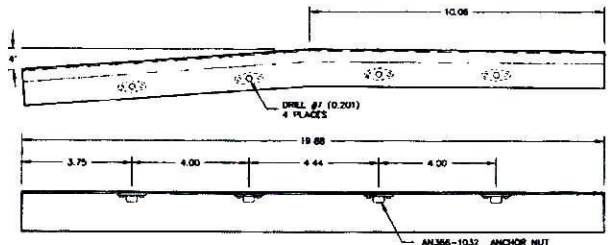
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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 7 OF 7
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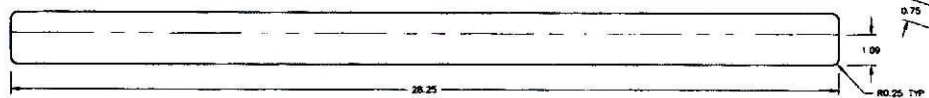
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2014-04-23

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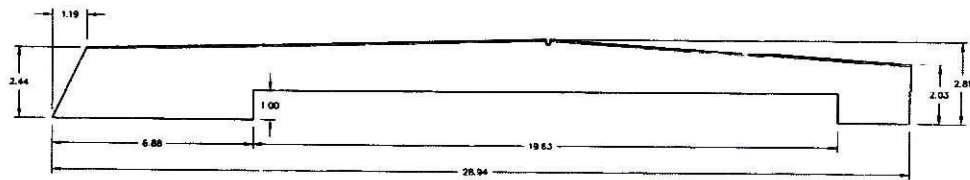
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
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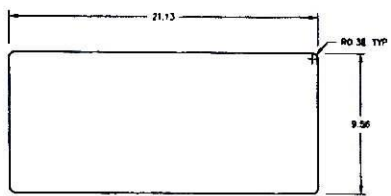
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SCALE 1 : 2



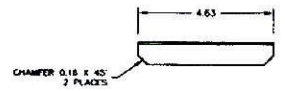
7 ANGLE
SCALE 1 : 2



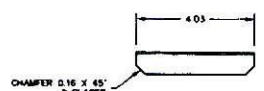
17 ANGLE
SCALE 1 : 2



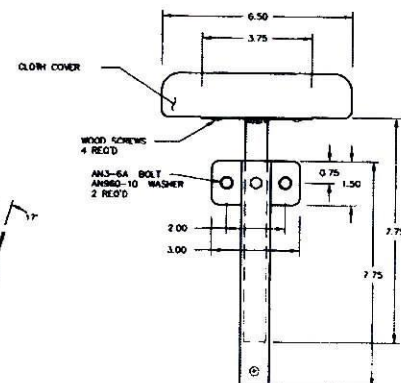
21 DOOR COVER PANEL
SCALE 1 : 4



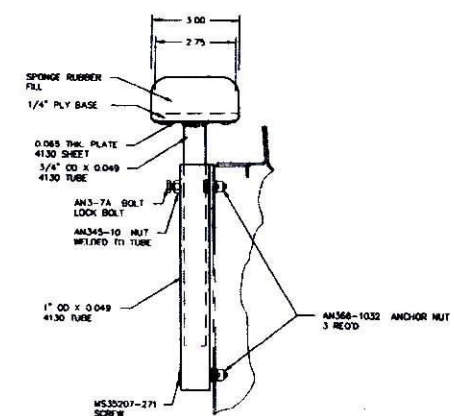
30 ANGLE
SCALE 1 : 2



33 ANGLE
SCALE 1 : 2



16 ARM REST ASSEMBLY
SCALE 1 : 2



QTY	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	34 REARWARD RIB WEB	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	33 ANGLE	ALUM. ALLOY 2024-T3	00-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	32 ANGLE	ALUM. ALLOY 2024-T3	00-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	31 FORWARD RIB WEB	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	30 ANGLE	ALUM. ALLOY 2024-T3	00-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	29 ANGLE	ALUM. ALLOY 2024-T3	00-A-200/3	0.75 X 0.75 X 0.063 EXTRUSION
1	21 DOOR COVER PANEL	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	18 DOOR HINGE SUB	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	17 ANGLE	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	16 ARM REST ASSEMBLY	AS NOTED		
1	15 INSTRUMENT PANEL	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	14 WINDOW RETAINER	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	13 INSTRUMENT WINDOW	G. E. LEXAN		0.063\"
1	12 FORWARD RIB	SUB-ASSEMBLY		
1	11 ANGLE	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	10 REARWARD RIB	SUB-ASSEMBLY		
1	9 ANGLE	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	8 PLACARD - INSTRUMENT PANEL	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	7 ANGLE	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	6 ALUMINUM STRIP	ALUM. ALLOY 2024-T3	00-A-250/5	0.040\"
1	5 RUBBER STRIP	COMMERCIAL		
1	4 DOOR TOP LATCH ASSEMBLY	AS NOTED		
1	3 PLEXIGLASS BUBBLE WINDOW	DART HARD PART NO. 2048-1033-1		
1	2 INSTALLATION - DOOR MOUNTED INSTRUMENTS			
1	1 INSTALLATION - BUBBLE WINDOW			

BASIC CODE

DASH NO FOR DIA
4-MTD HEAD NEAR SIDE
1-MTD HEAD FAR SIDE

DASH NO FOR LENGTH

DIMENSIONS
DOT = # OF SHEETS
TO BE DRAILED
C-COUNTERSINK

BASIC CODES:
BJ = W2047090
BH = W2046240
LZ = W2047090
CX = W2047000

* INSTALL NEW RIVET
+ REMOVE/REPLACE RIVET
- EXISTING RIVET

APPROVALS

DRAWN: E. BURHOON 1 OCT 91

CHECKED: E. BURHOON

SWISS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS ANGLES
X.00X ±0.010 ±1/2°
X.00 ±0.03 ±1/2°
X.X ±0.1

AERO DESIGN LTD.
CONSULTING ENGINEERS, DESIGNERS AND MANUFACTURERS
805 HATFIELD ROAD N.E. CALGARY, ALBERTA, T2E 7G8
EAGLE COPTERS LTD.
BELL 204, 205, 212 & 214
VERTICAL REFERENCE DOOR
PARTS FABRICATION

SCALE AS NOTED
SHEET 2 OF 3

REV 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039102

Supplier: EAC002-VU
Eagle Copters Maintenance Ltd.
823 McTavish Road N E
Calgary
AB
T2E 7G9 Canada
Phone: 403-250-7370

PO No: PO039102

PO Date: 2/23/18

Due Date: 3/13/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAR 01 2018

Revised

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	D4324-045P		Cushion Assembly As Per Dwg D4324 Rev. B	Firmed	3/13/18	4 pcs	4 pcs	4 pcs	\$108.94/pcs	\$435.76

Line Item Note job# 172283

Grand Total: \$435.76

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

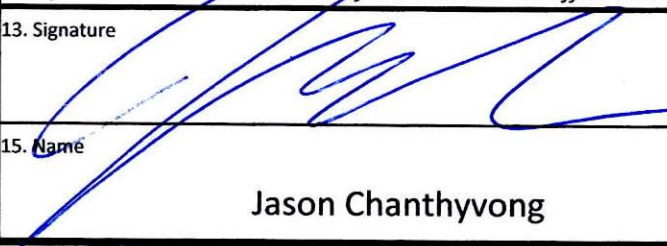
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CH.

Plex 3/1/18 7:41 AM dart.baker.diane

PHB

1. Organization issuing certificate Aerotex Interiors Inc., #151-2340 Pegasus Way NE Calgary, AB T2E 8M5		2. CERTIFICATE OF CONFORMANCE		3. Work Order / Contract / Invoice W8196	
4. Customer Name/Address Eagle Copters Maintenance 823 McTavish Road NE Calgary, AB T2E7G9				5. Purchase Order 18-000740	
6. Item	7. Description	8. Part Number	10. Quantity	11. Batch No.	12 Status
1	Pad, armrest (Grey)	EA20469-16-1	5		New
12. Remarks <i>It is hereby that Aerotex Interiors, Inc. is an approved distributor. The products, articles or parts referenced on this document are in new or overhauled condition and were purchased from an approved source (FAA, EASA, TCCA, Mil Spec or Commercial). The Original Manufactures' Certifications are maintained on file at our central office location, and copies are available upon request.</i>					
13. Signature 		14. Title General Manager			
15. Name Jason Chanthyvong		16. Date 01/03/2018			

